

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006292**Date Inspected:** 11-Apr-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Fabrication**Summary of Items Observed:**

CWI Inspector: Mr. Zhu Zhong Hai

OBG Bay 13 and Bay 14

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

ZPMC QC representative Mr. Fu Yuhong presented this QA Inspector, Mr. Paul Dawson, with "Inspection Notification Document" #02588 which states twelve OBG Deck Plates are ready for green tagging in OBG bay #13 and bay #14. This QA Inspector accompanied Mr. Fu Yuhong and ABF representative Mr. Primo Chan to OBG bay #13 and #14. This QA Inspector performed random observations of these twelve Deck Plates and this QA Inspector concurred with issuance of green tag releases of the OBG Deck Plates. The QA Inspector wrote lot number B254 on each of the green tag documents, below where Mr. Primo Chan and Mr. Fu Yuhong have signed these sheets. Below is a list of the OBG Deck Plate welds and the applicable green tag numbers:

DP332-001~008 Green tag 6538

DP495-001~006 Green tag 6539

DP357-001~010 Green tag 6540

DP275-001~006 Green tag 6541

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DP273-001~006 Green tag 6542  
DP113-001~008 Green tag 6543  
DP138-001~010 Green tag 6544  
DP219-001~010 Green tag 6545  
DP192-001~010 Green tag 6546  
DP251-001~010 Green tag 6547  
DP165-001~010 Green tag 6548  
DP226-001~010 Green tag 6549

OBG Bay 19

The QA Inspector observed ZPMC welder Mr. Cai Hailong, stencil 062749 is using welding procedure WPS-B-T-2132 to make flux cored fillet welds between stiffeners and OBG bottom plate BP025-006. The QA Inspector observed ZPMC Quality Control Inspector Mr. Sheng Jiang Guo had recorded Mr. Hailong to have a welding current of approximately 315 amps and 31 volts and the base material appears to have been preheated with a torch prior to welding. Items observed by the QA Inspector appear to comply with project specifications.



### Summary of Conversations:

See above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Dawson,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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